

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024741**Date Inspected:** 14-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG	

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Trial Assembly, OBG segment 14 East

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13AW welds as part of a special reinspection program reference NWIT# 9480. This QA Inspector observed China Classification Society Industrial Corporation (CCSI) magnetic particle (MT) Inspection personnel performing MT inspections of welds: SEG3019AG-041, 043, 045, 002, 028, 003, 030, 032; SEG3019S-174, 175, 182, 183, 178, 179. This QA Inspector performed random magnetic particle inspection of the following welds: SEG3019AG-041, 043, 045, 002, 028, 003, 030, 032; SEG3019S-174, 175, 182, 183, 178, 179 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

Trial Assembly, OBG segment 14 West

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections of segment 13AW welds as part of a special reinspection program Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13AW welds as part of a special reinspection program reference NWIT# 9480. This

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QA Inspector was informed by ABF Inspectors that they have completed and accepted MT inspections of welds: SEG3020AL-182, 184, 185, 187, 189, 190, 192, 194, 195, 197, 199, 200, 202, 204, 205, 207, 209, 210, 212, 214, 215, 217, 219, 220, 222, 224, 225, 227, 229, 230, 232, 234, 235, 237, 239, 240, 242, 244, 245, 247, 249, 250, 252, 254, 255, 257, 259, 260 and SEG3020P-063, 113, 114, 115; SEG3020AL-183, 193, 198, 203, 208, 218, 223, 233, 238, 233, 248, 253, 258 and they have rejected welds SEG3020AL-188, 228, 263. This QA Inspector performed random magnetic particle inspection of welds SEG3020AL-233 and 238 and rejectable linear indications were observed at the top ends of both of these welds. Welds SEG3020AL-193, 208, 213, 218, 223, 253 and 258 appear to comply with AWS D1.5 MT and visual requirements. No ABF or ZPMC personnel were available to resolve these MT and VT rejections. This QA Inspector reported these results to dayshift personnel for followup inspections. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report

### Summary of Conversations:

See Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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